

Wednesday, September 27, 2017 7:56:42 AM

166531

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N900040100

Setup Start *NS1*

Stop *NS2*

30

Cust Item ID:

30

Customer:

Required Date: 9/27/2017 **Req'd Qty:** 30.00

Reference:

Date: _____ **Tooling:** _____

Date: _____

Run Start *NR1*

QC:

Date: SEP 26 2017 **SPC (Y/N):**

Date:

Stop *NR2*

[illegible]

Work Order ID 166531

166531

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Item ID: D2022-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 9/27/2017 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 9/27/2017 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *121* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.60				30	0		17/09/27
125 *126* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				30	0		2017-09-27 JSL
127 *128* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				30			DAS 38 9-89 SEP 27 2017

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Item ID: D2022-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 9/27/2017 Start Qty: 30.00

30

Cust Item ID:

Required Date: 9/27/2017 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Identify as per dwg & Stock Location: 9001

0.00

Memo

0.30

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

3.00

30

SEP 26 2017
DASDAS
21
9-89

SEP 27 2017

um 17/9/27

DAS
21
9-89

Picklist Print

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Page 1

Work Order ID: 166531

166531

Parent Item: D2022-101

D2022-101

Parent Item Name: Spacer

Start Date: 9/27/2017

Required Date: 9/27/2017

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP D02.03.07 Now made in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased			No	100	f	18.7360	0.03	0.9			

M6061T6R0 750

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

18.736

m137513

9.934

m138346

8.802

0.844

DAS
23
9-89

17/9/27

8 7 6 5 4 3 2 1

D

D

C

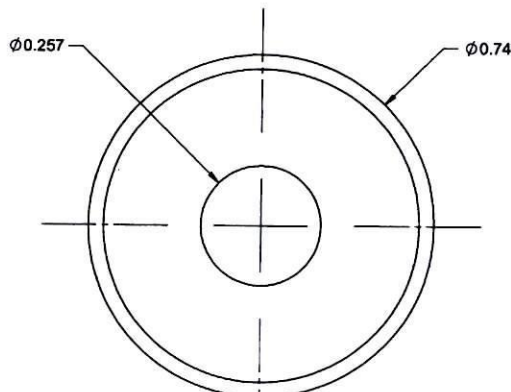
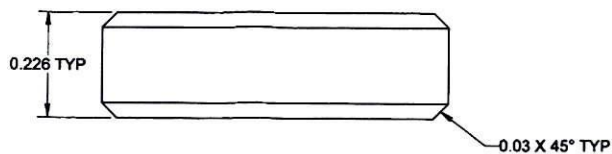
C

B

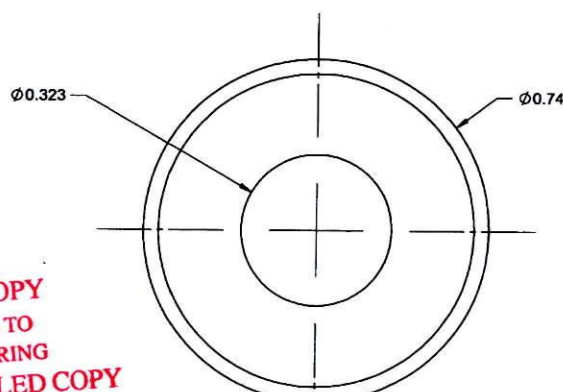
B

A

A



D2022-101 SPACER



D2022-103 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166531 MWS
17-09-27

RELEASED
2014-08-27

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T62 ALUMINUM ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4180) OR ASTM B211 OR ASTM B221 (REF DART SPEC M6061T6R0.750)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2022-101" OR "D2022-103" PER QSI 044 6.7
- 7) WEIGHT: 0.01 lbs

B	RE-FORMAT DRAWING	DB	14.03.12
A	NEW ISSUE	JB	90.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D2022	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPACER	NTS
DATE	14.03.12	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1